

Work Order ID 72983

Tuesday, August 23, 2011 8:29:44 AM



Aug 31/87

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350)

Start Date: 8/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/29/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *ll*

Date: 11/08/23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4018

C

100

Weld per dwg A/R S.S. rod Batch: *M114649* 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

PMB 11/08/23

11.08.30

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11.08.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/02/30

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

M 115128.

0.00

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: *4:00*

Oven Temperature: *320°*

Finish Time: *7:30.*

D

BR 11-8-30.

140

Wing Walk as per dwg QSI005 4.4 Batch *117863*

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

Install placard and label as per dwg

***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

1

BR 11-8-31.

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 4 M 11/08/31

160

Identify as per dwg & Stock Location: 6-A

0.00



Packaging

Memo

0.00

Packaging

w/o
72981

GS 11/09/02

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/12
MF 11-09-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Tuesday, August 23, 2011 8:29:49 AM

Page 1

Work Order ID: 72983

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)




Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1  Rib		Manufactured	No			100	Each	8.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
				72545		8				2			
D4018-3  Rib		Manufactured	No			100	Each	8.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				72546		6				2			
				WA005		2							
				68479		2							
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	25.0000	3	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		18							
				72116		18							
				WA005		7							
				71941		7				3			

PMB 11/08/25

PMB 11/08/25

PMB 11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 23, 2011 8:29:49 AM

Page 2

Work Order ID: 72983

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5
Rib
Manufactured No

100 Each 40.0000 6 6

PMB 11/08/25

Location Loc Qty Loc Code

WA 65428

70758 40
71939 5
72339 3
72544 13
72544 19

4

2

D4035-041
Lid Rib Assembly, Fwd (350 Basket)
Manufactured No

100 Each 7.0000 1 1

PMB 11/08/25

Location Loc Qty Loc Code

WA 7
63720 0
72541 3
72657 4

1

D4035-043
Lid Rib Assembly, Aft (350 Basket)
Manufactured No

100 Each 3.0000 1 1

PMB 11/08/25

Location Loc Qty Loc Code

WA006 3
72439 3

1

D2581
Mounting Bracket
Manufactured No

100 Each 39.0000 2 2

PMB 11/08/25

Location Loc Qty Loc Code

WA 39
69258 28
69739 2
70766 9

2

Tuesday, August 23, 2011 8:29:50 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 23, 2011 8:29:50 AM

Page 3

Work Order ID: 72983

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 8/23/2011

Required Date: 8/29/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-7 Manufactured No

100 Each

1.0000

1

1



Mesh (350 Basket Short, Lid)

Location

Loc Qty

Loc Code

FG

1

68523

1

100

Each

9.0000

1

1

D4021-3

Manufactured No



Data Plate

Location

Loc Qty

Loc Code

WA

9

71943

9

140

Each

0.0000

1

1

D2728-3

Manufactured No



Dart Logo label

115050.

Pl 11-08-24
B 72430 → ①

RMB 11/08/25

1 BR 11-8-31.

Tuesday, August 23, 2011 8:29:50 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

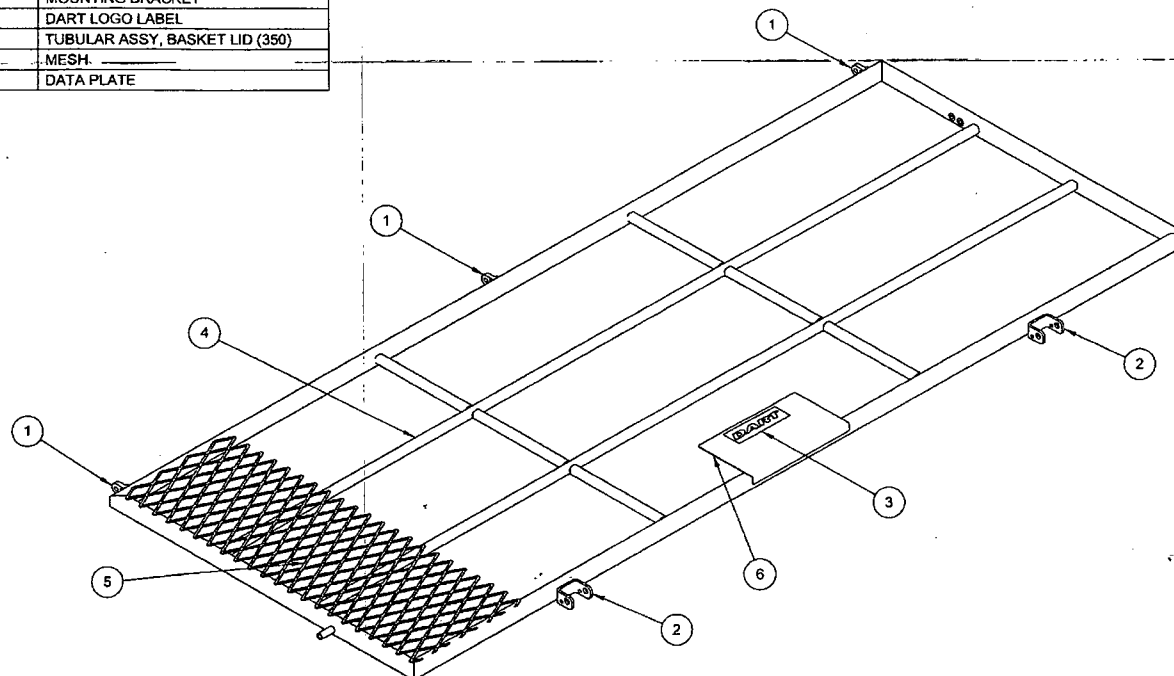
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



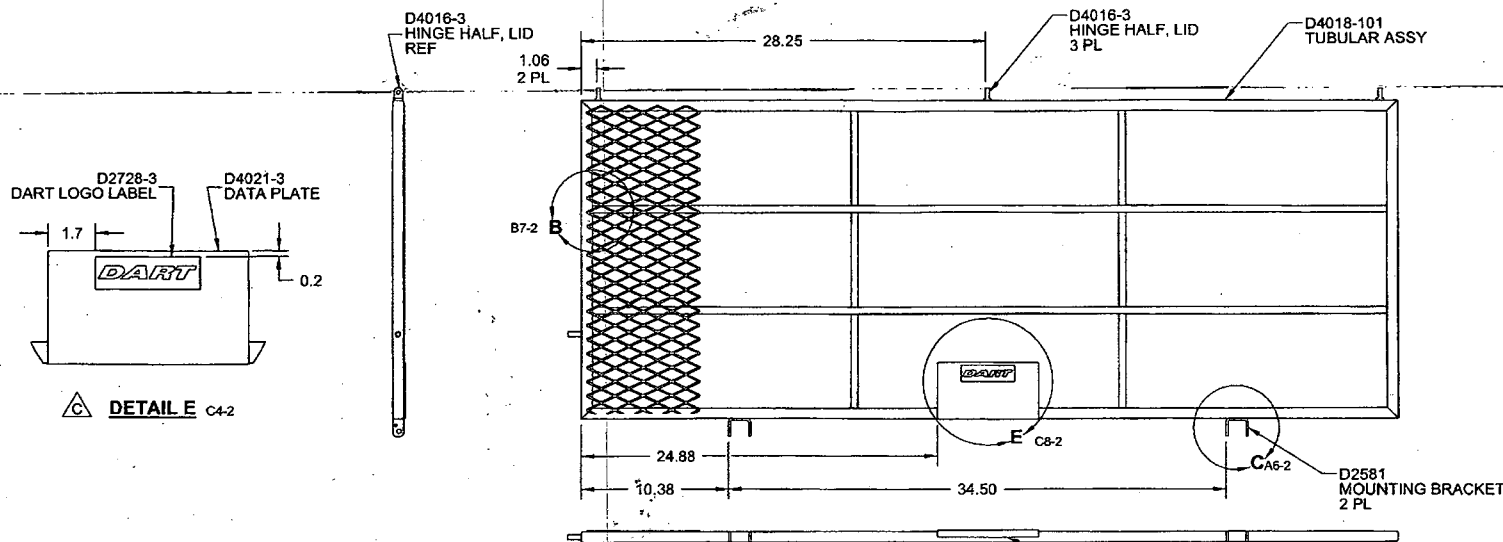
D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72283

11-08-73

RELEASED
10.08.05
ECW 10-916

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED, DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>ALS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. C SHEET 1 OF 4 TITLE SHORT BASKET LID ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>SC</i>		
CHECKED	<i>SC</i>		
MFG. APPR.	<i>MD</i>		
APPROVED	<i>MD</i>		
DE APPR.	<i>MD</i>		
DATE	10.08.05		



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10/08/12

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.5 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

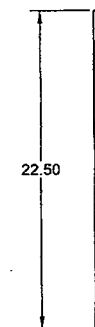
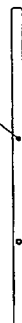
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350)	
DATE	10.08.05	NTS	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

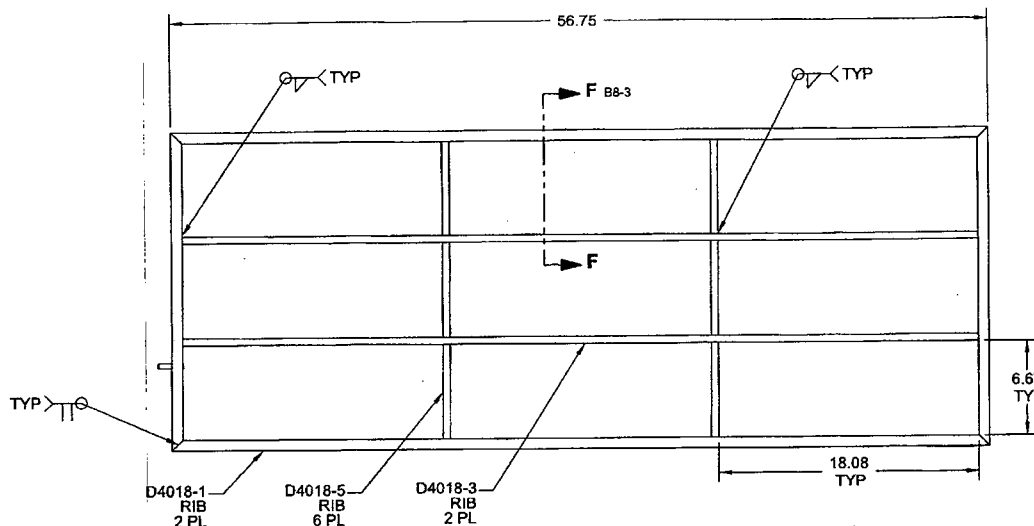


D4035-041
RIB ASSY, FWD

SECTION F-F C3-3



D4035-043
RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

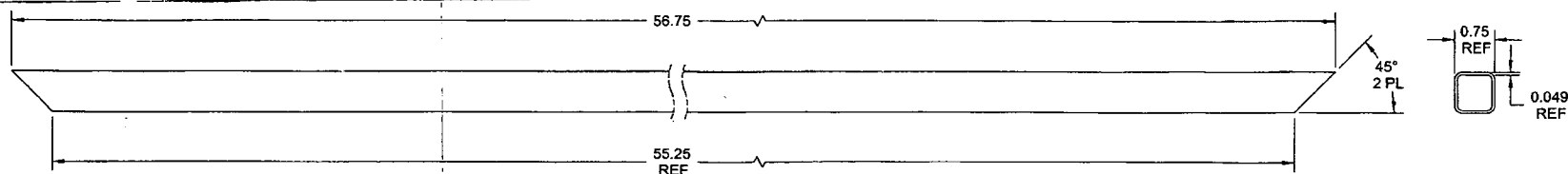
DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350) NTS	
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RELEASED
10.08.12 UP

8 7 6 5 4 3 2 1

D

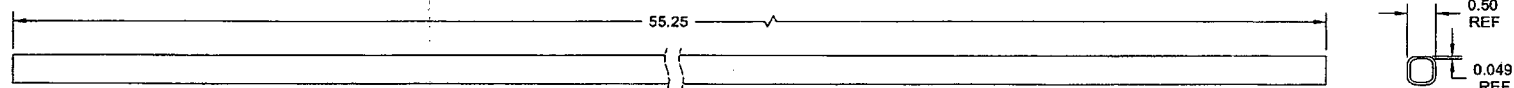
D



D4018-1 RIB

C

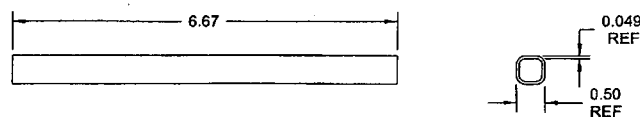
C



D4018-3 RIB

B

B



D4018-5 RIB

72983

RELEASED
10.08.05

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AIS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	sc	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350) NTS	
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8 7 6 5 4 3 2 1

A

A